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FEXOFENADINE HYDROCHLORIDE V

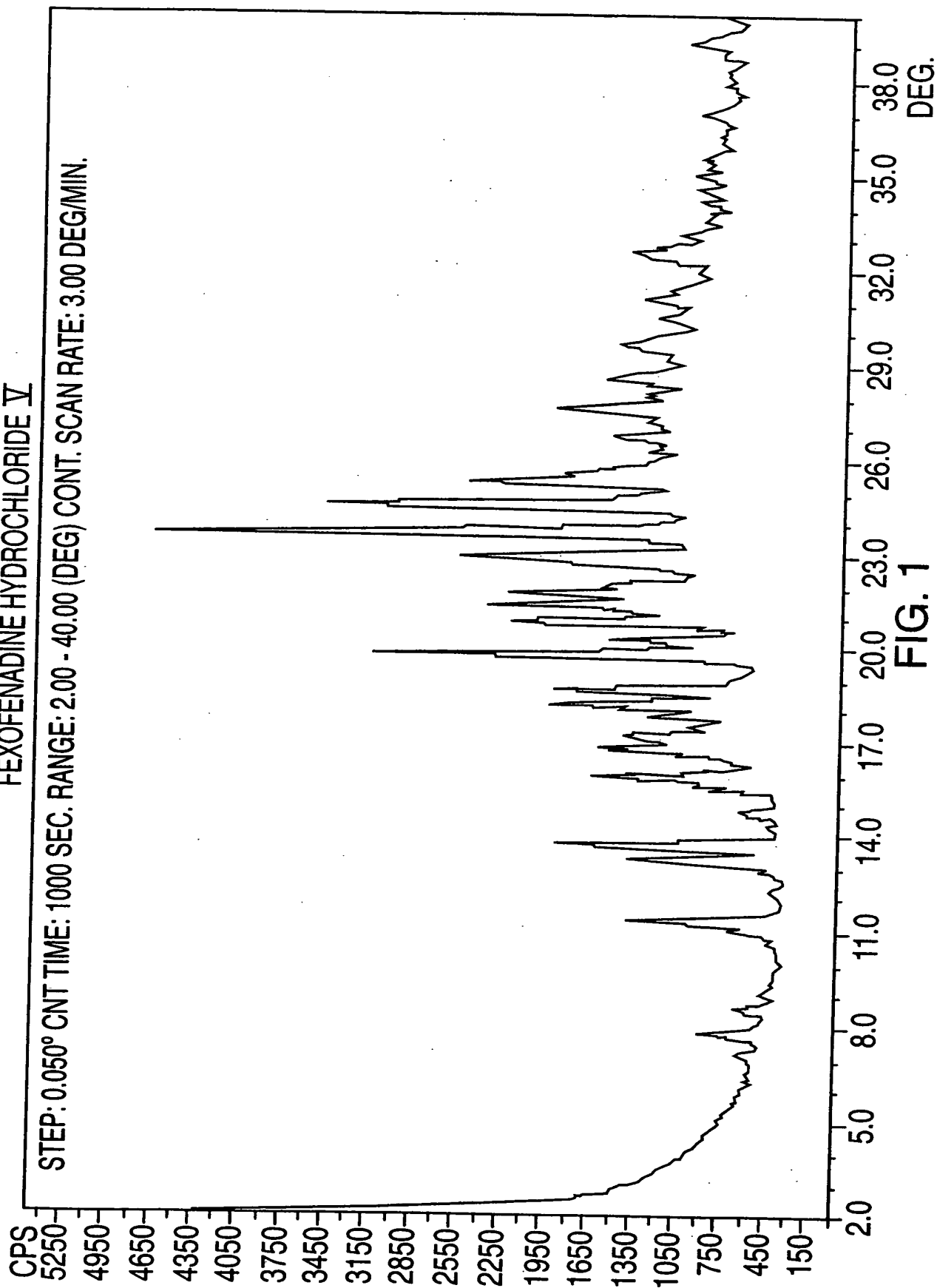


FIG. 1

FEXOFENADINE HYDROCHLORIDE VI

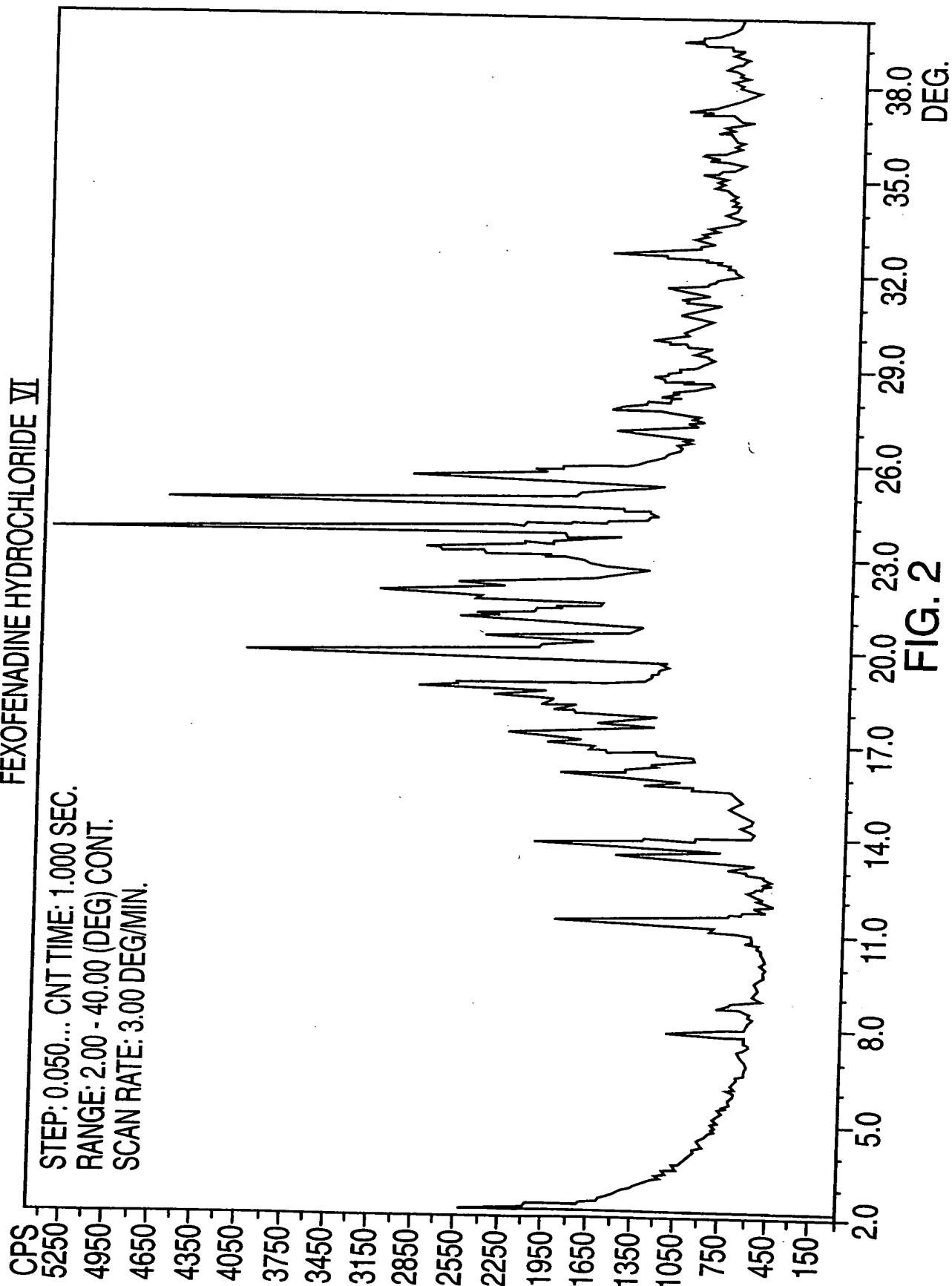


FIG. 2

FEXOFENADINE HYDROCHLORIDE VII

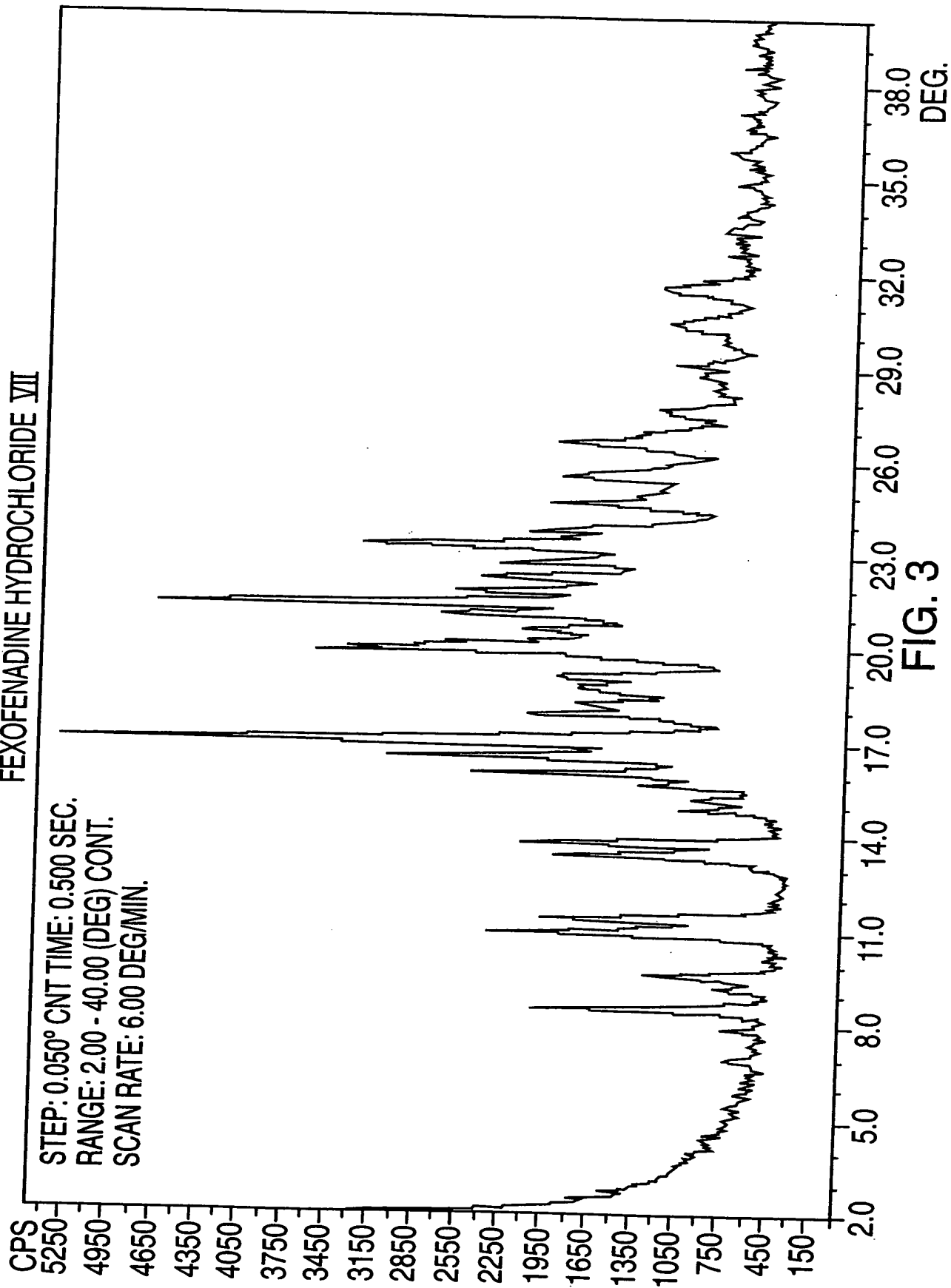
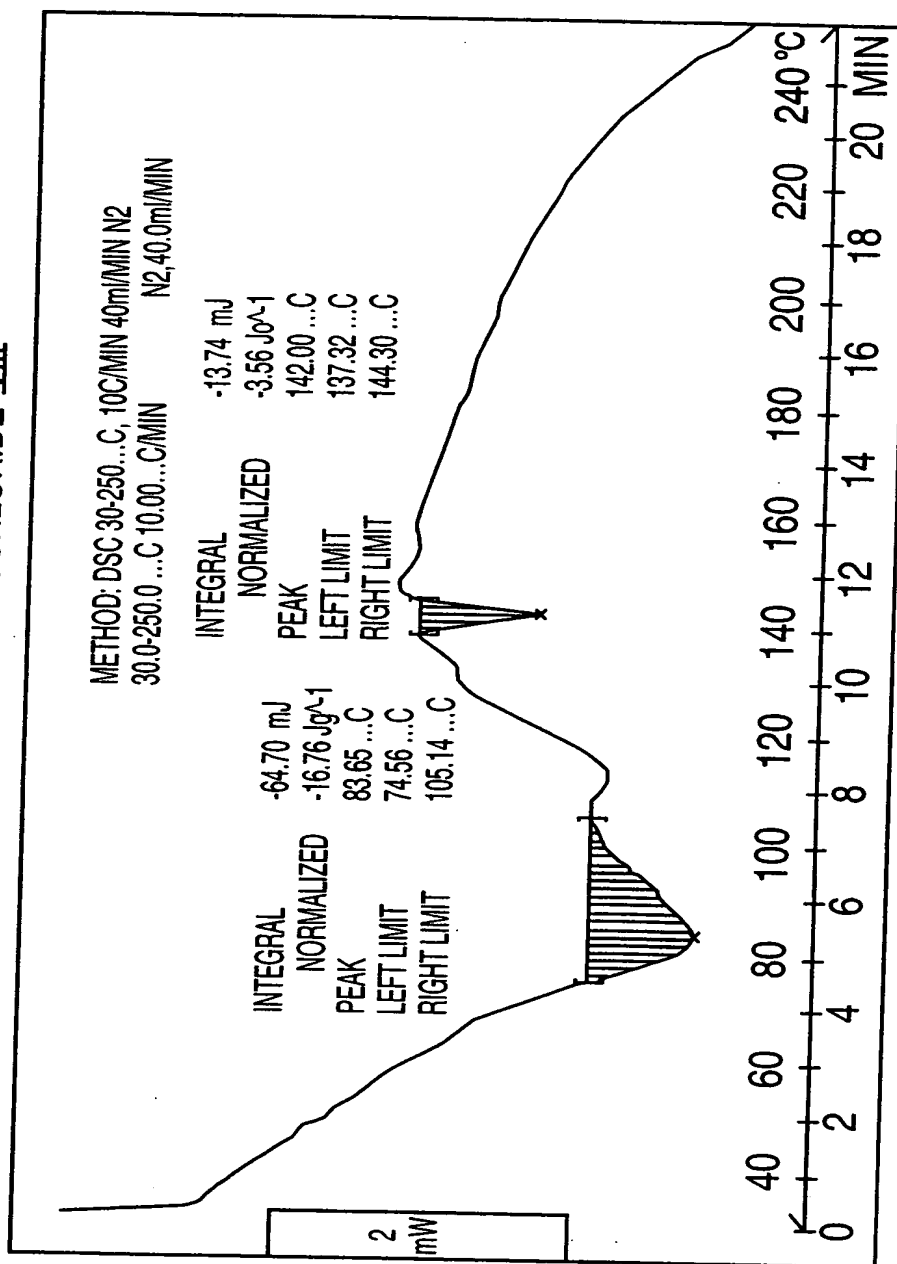


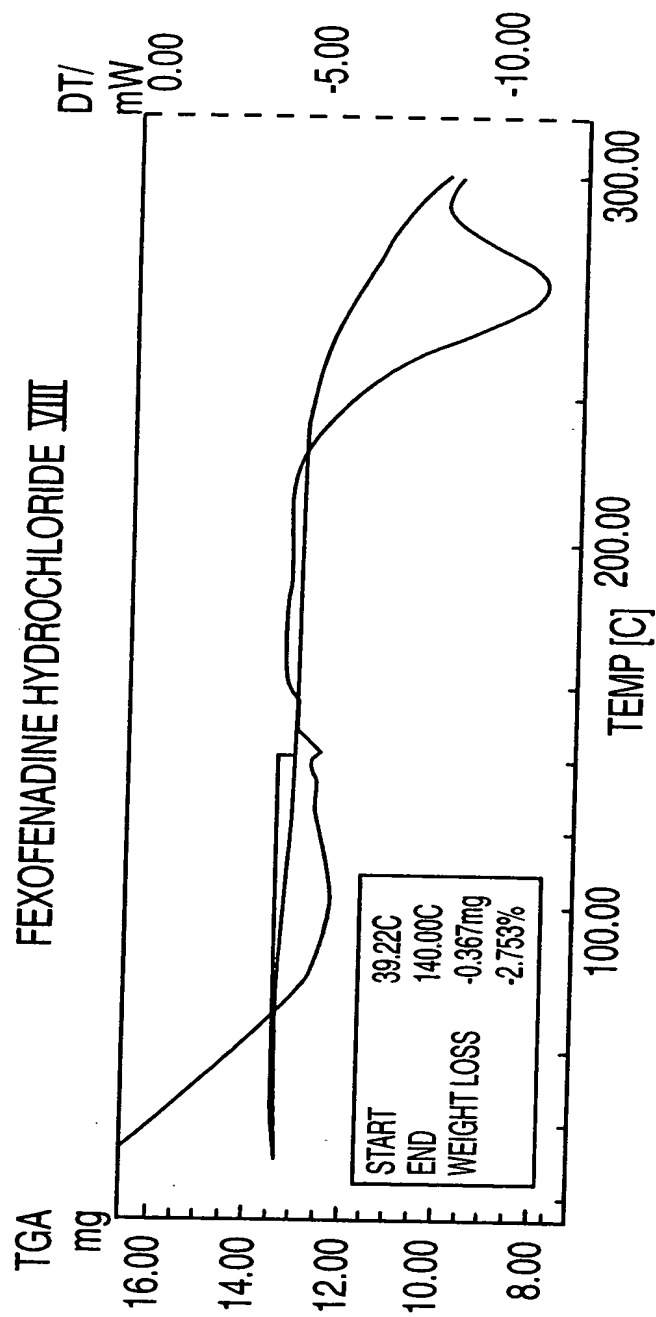
FIG. 3

FEXOFENADINE HYDROCHLORIDE VIII



DSC OF THERMOGRAM OF FEXOFENADINE FORM VIII

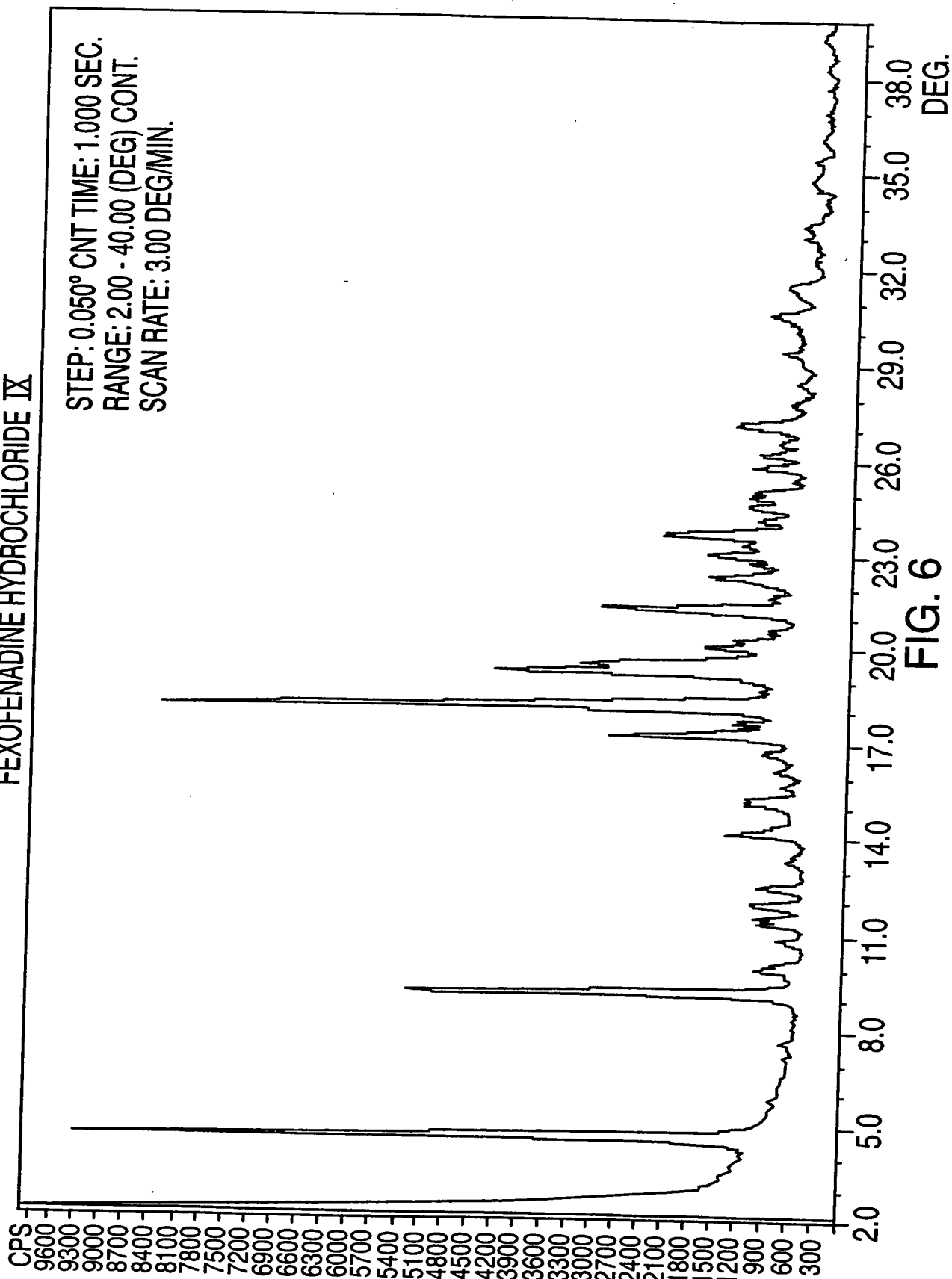
FIG. 4



TGA OF FEXOFENADINE FORM VIII

FIG. 5

FEXOFENADINE HYDROCHLORIDE IX



FEXOFENADINE HYDROCHLORIDE FORM IX

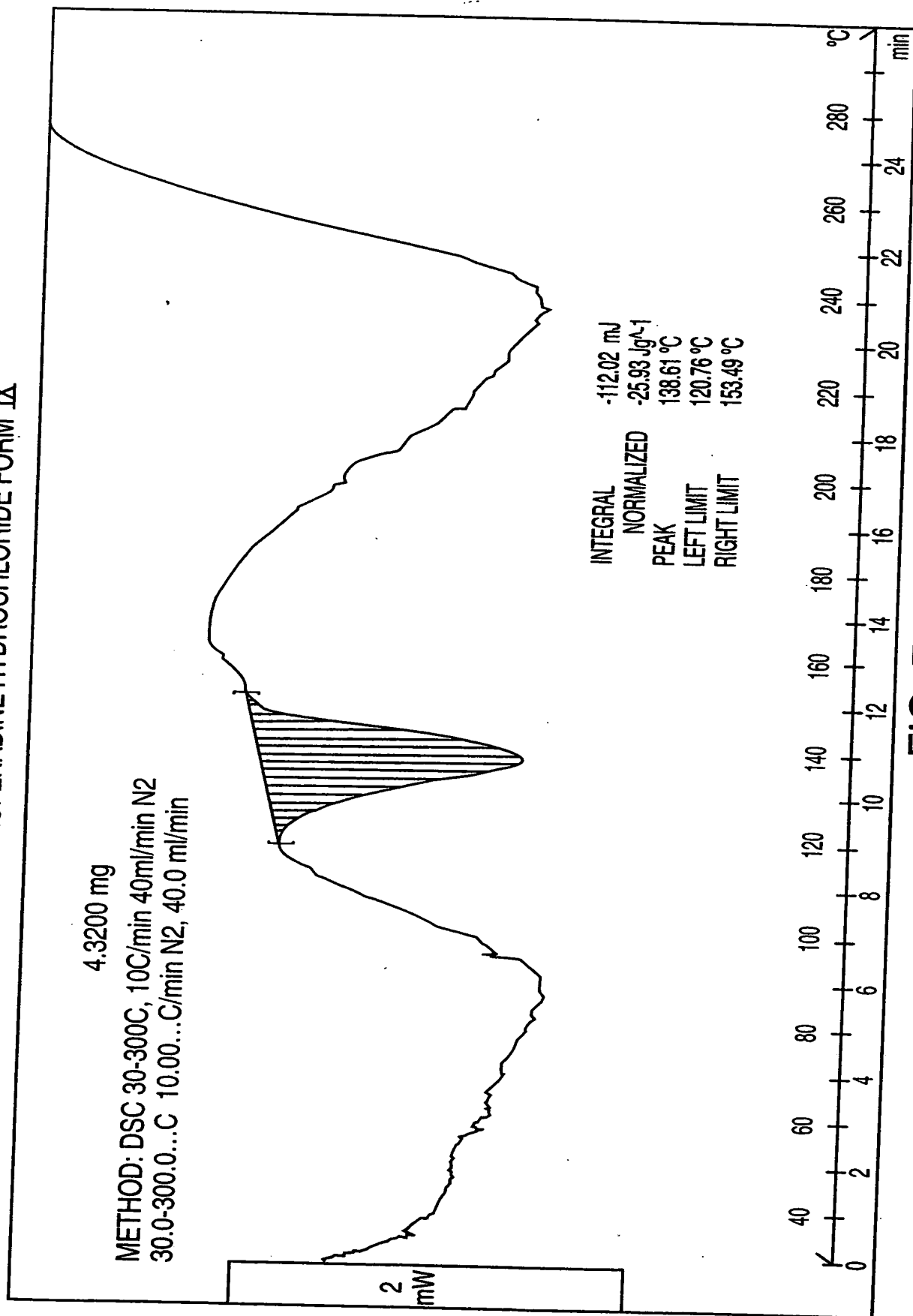


FIG. 7

DTG-50 THERMAL ANALYSIS RESULT

(TEMP PROGRAM)
TEMP RATE HOLD TEMP HOLD TIME
(C/min) (C) (min)
10:00 200.0 0

FEXOFENADINE HYDROCHLORIDE FORM X

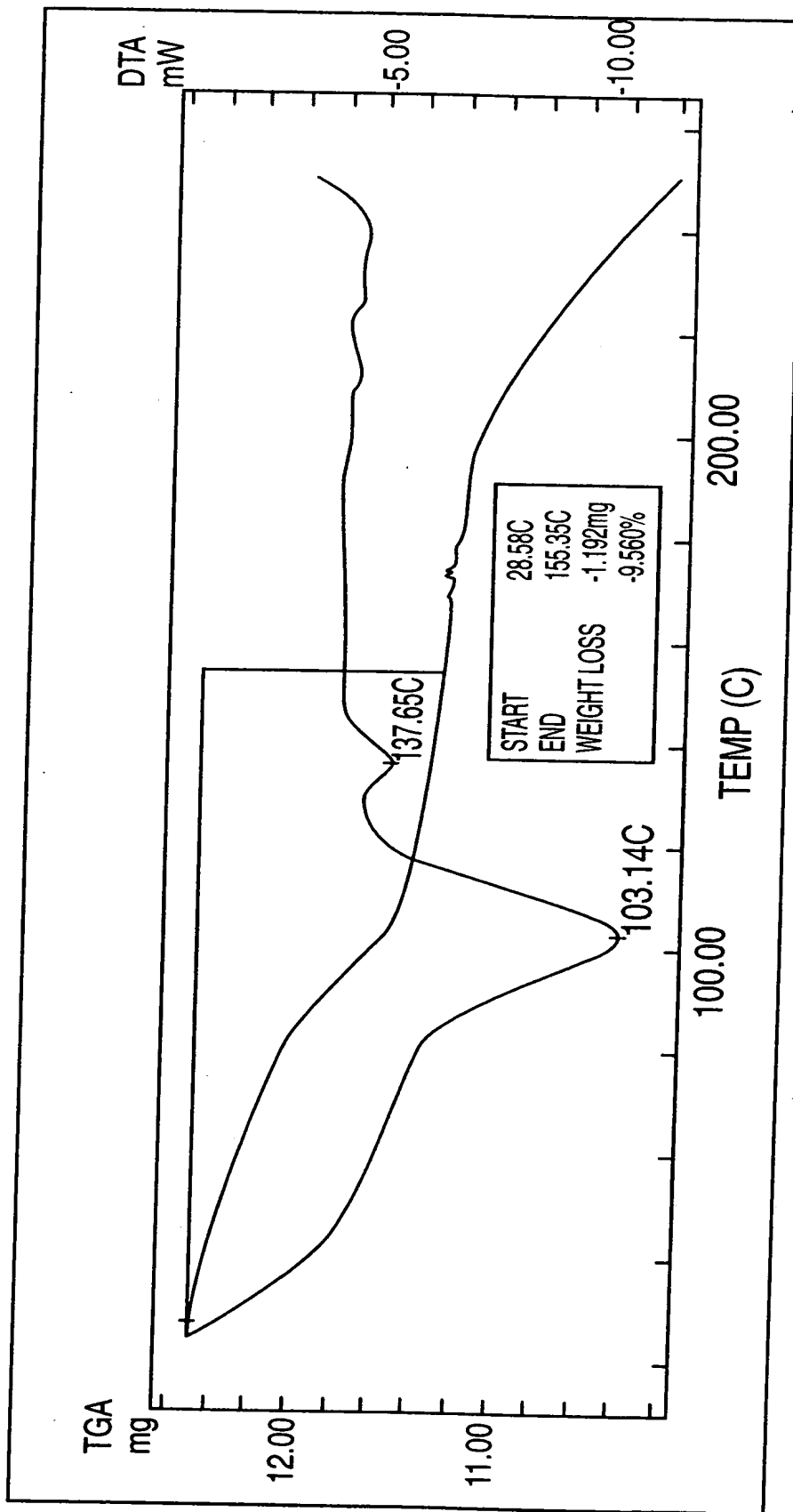


FIG. 8

FEXOFENADINE HYDROCHLORIDE X

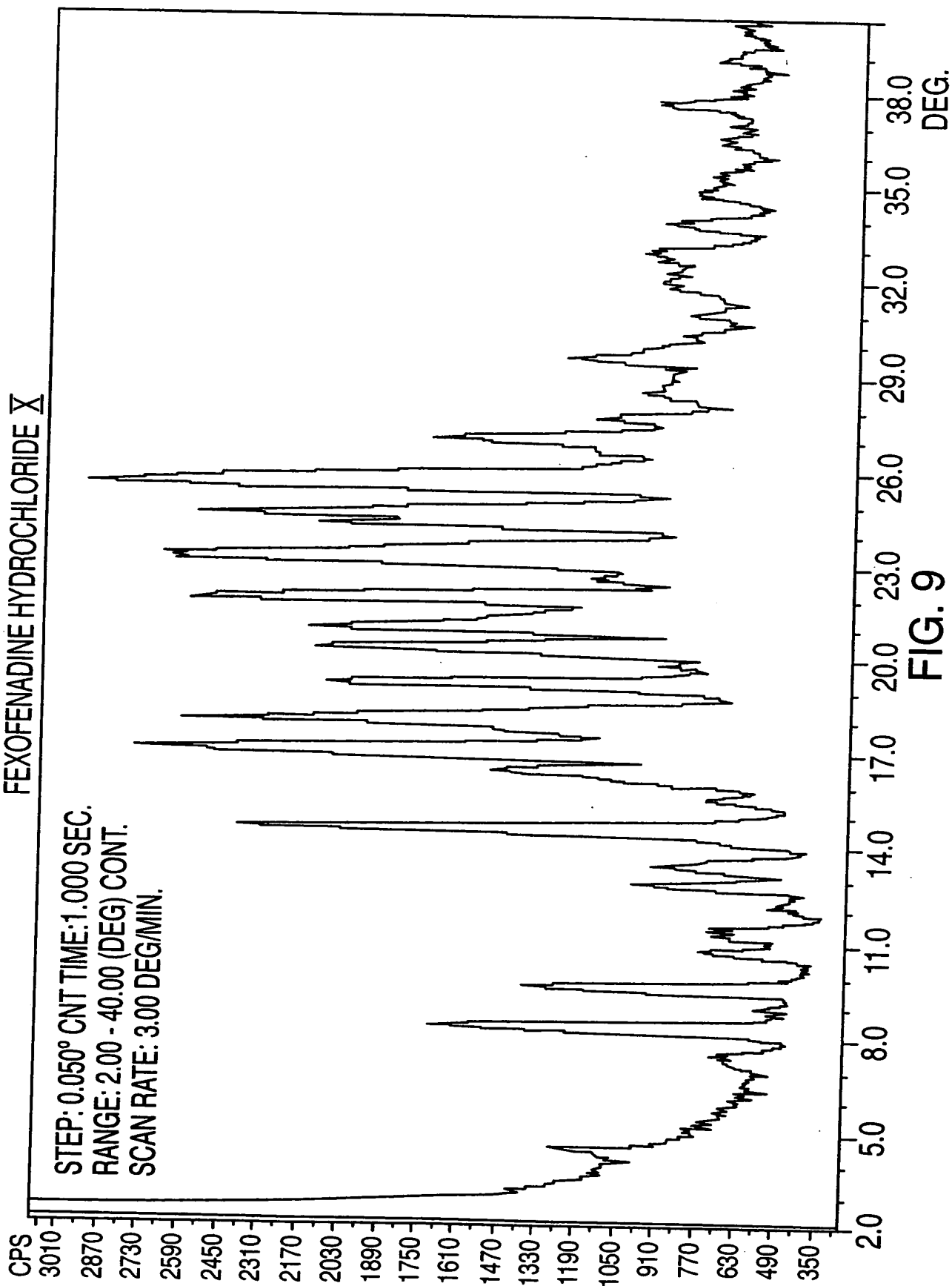
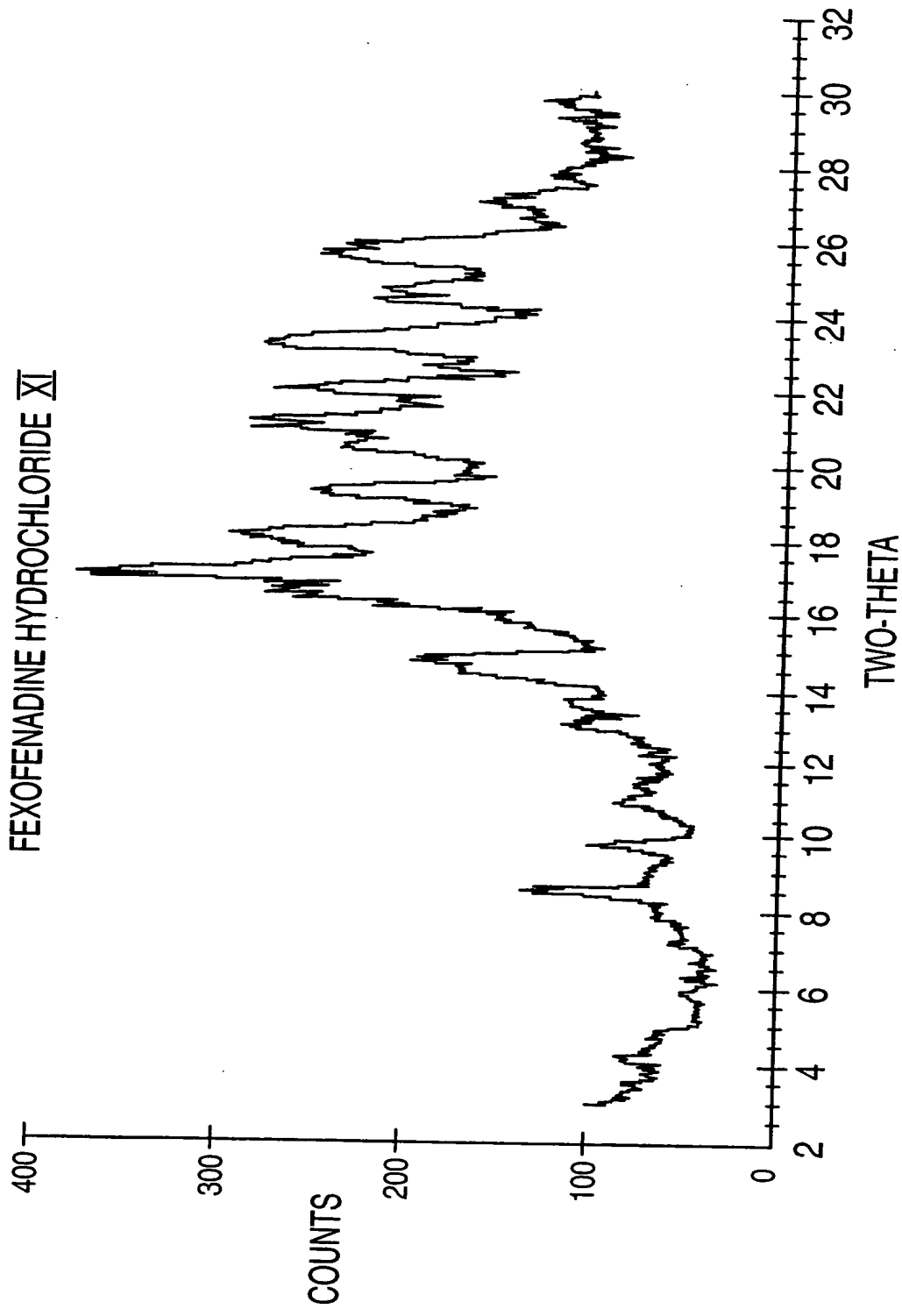


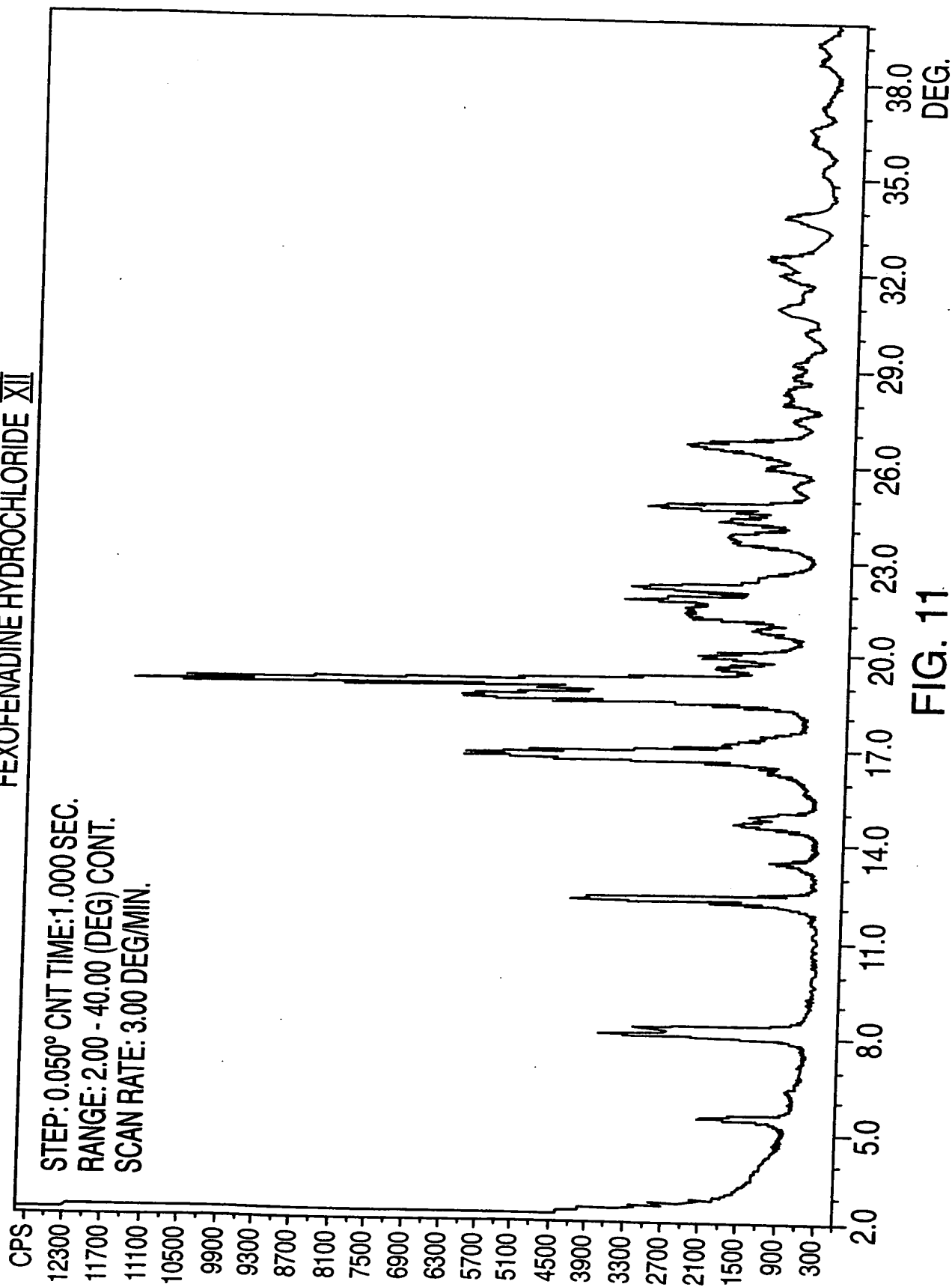
FIG. 9



TWO-THETA MIN	3.00	RECEIVING SLIT (MM)	0.2
TWO-THETA MAX	30.00	SCATTERING SLIT (MM)	1
STEP SIZE	.05	KV	40
COUNT TIME (SEC)	.50	ma	28

FIG. 10

FEXOFENADINE HYDROCHLORIDE XII



FEXOFENADINE HYDROCHLORIDE XII

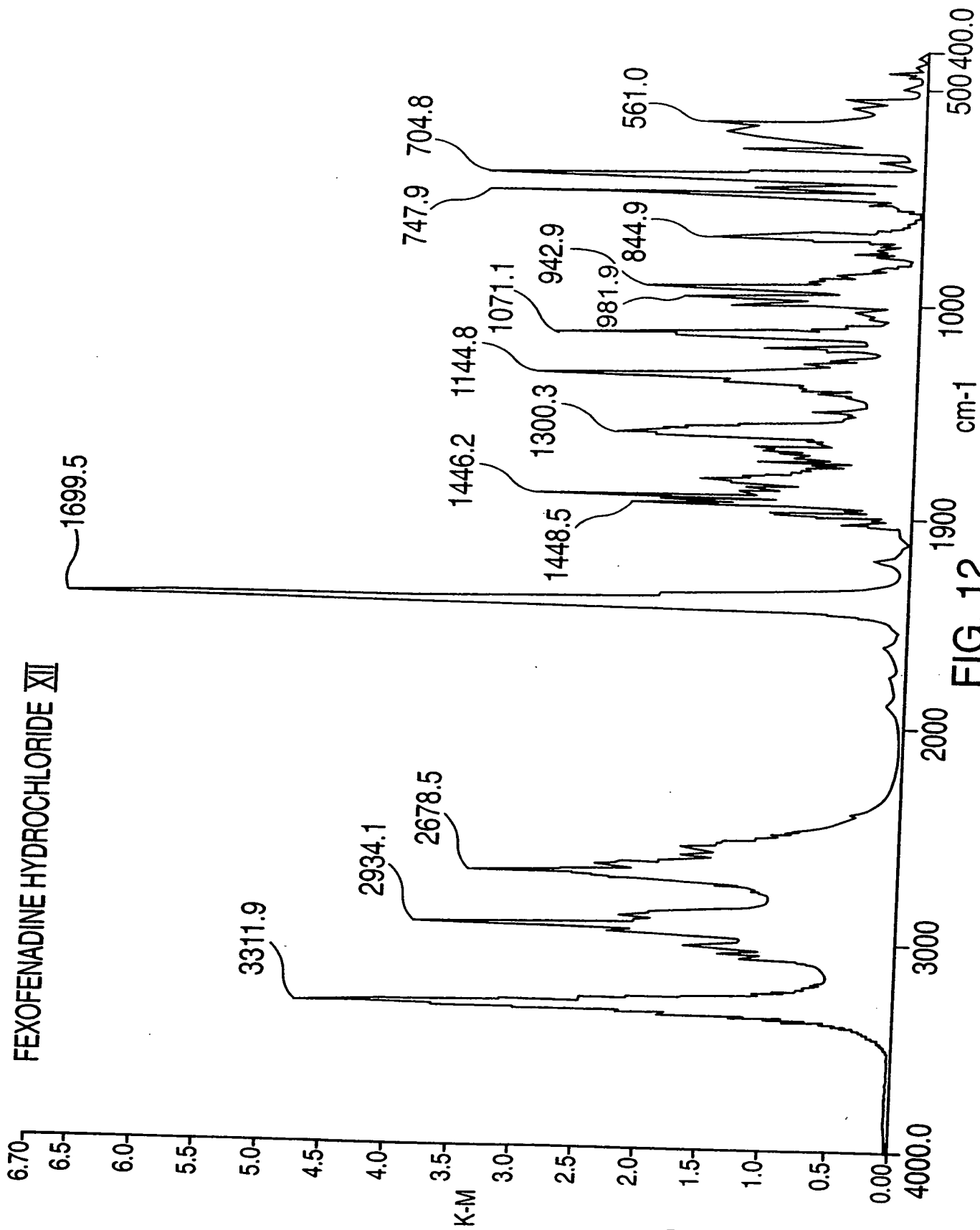


FIG. 12

FEXOFENADINE HYDROCHLORIDE XIII

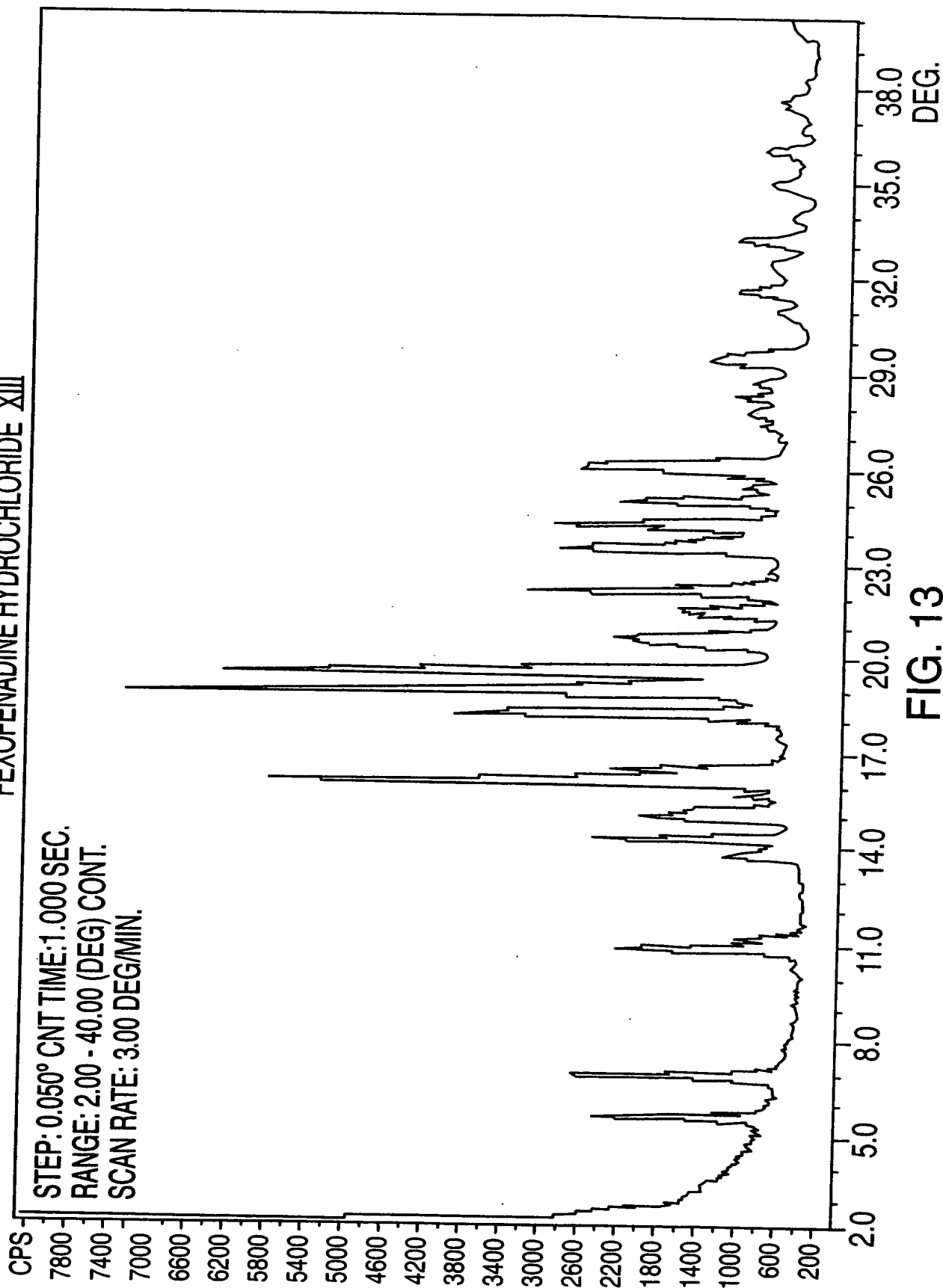


FIG. 13

FEXOFENADINE HYDROCHLORIDE XIII

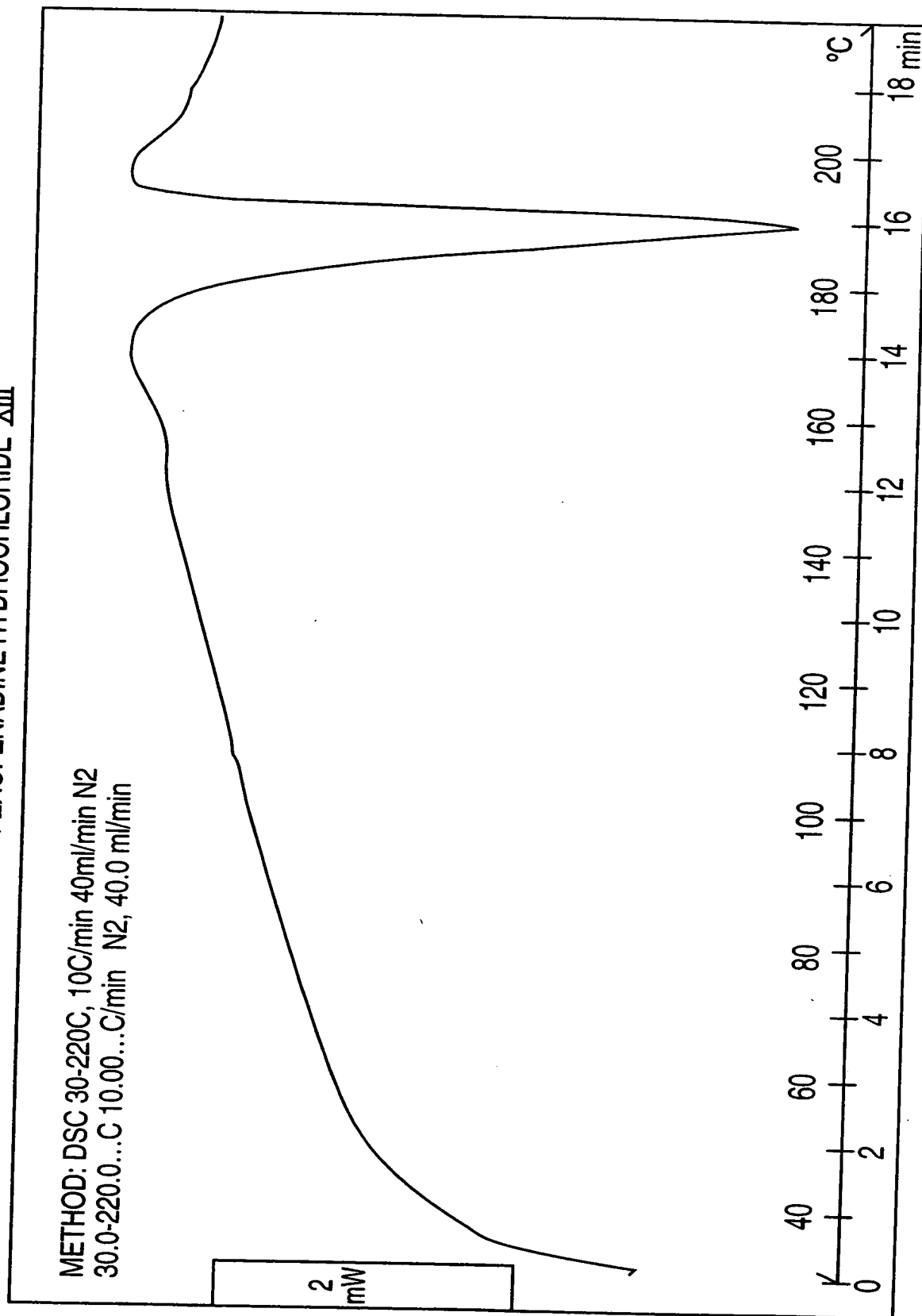


FIG. 14

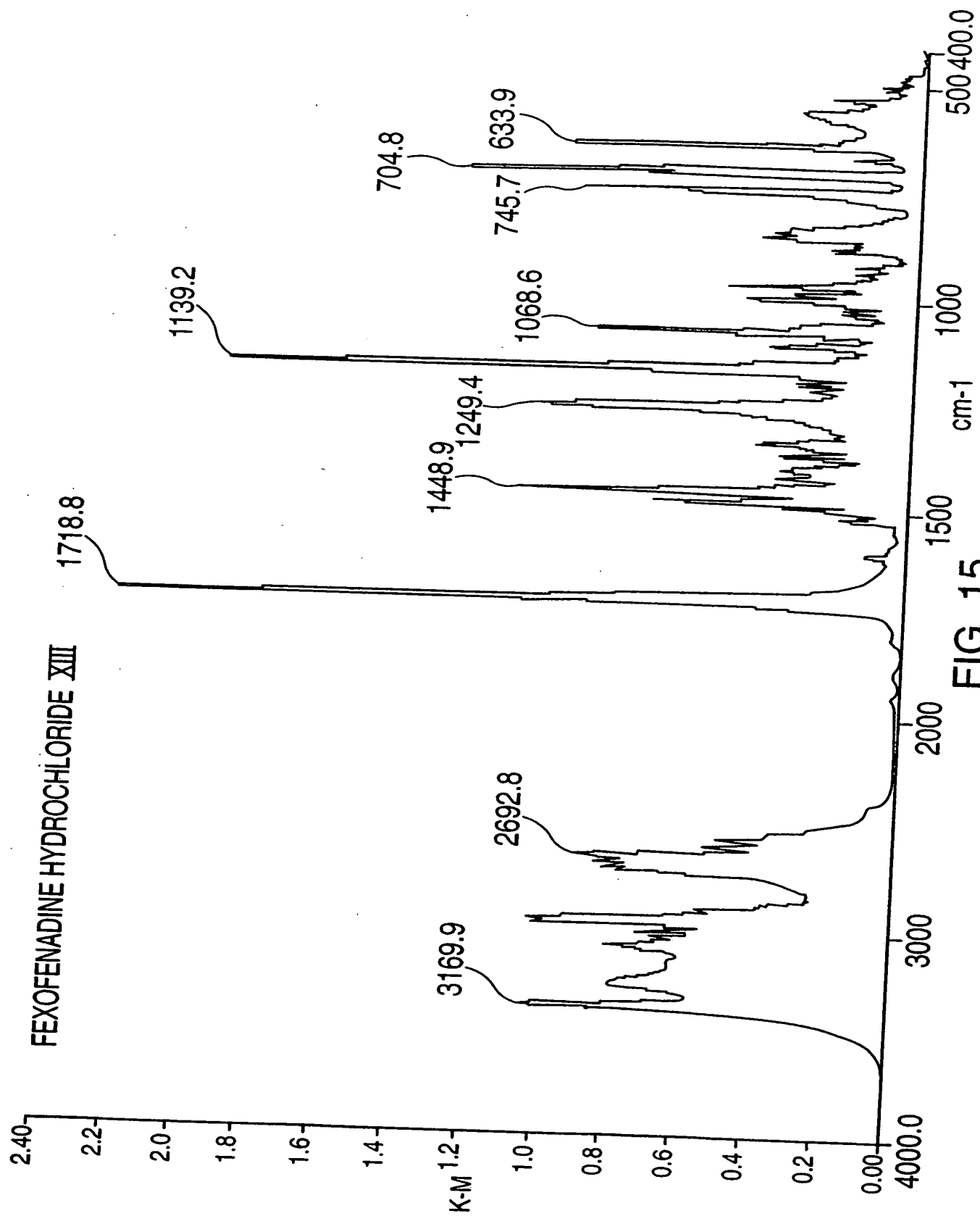
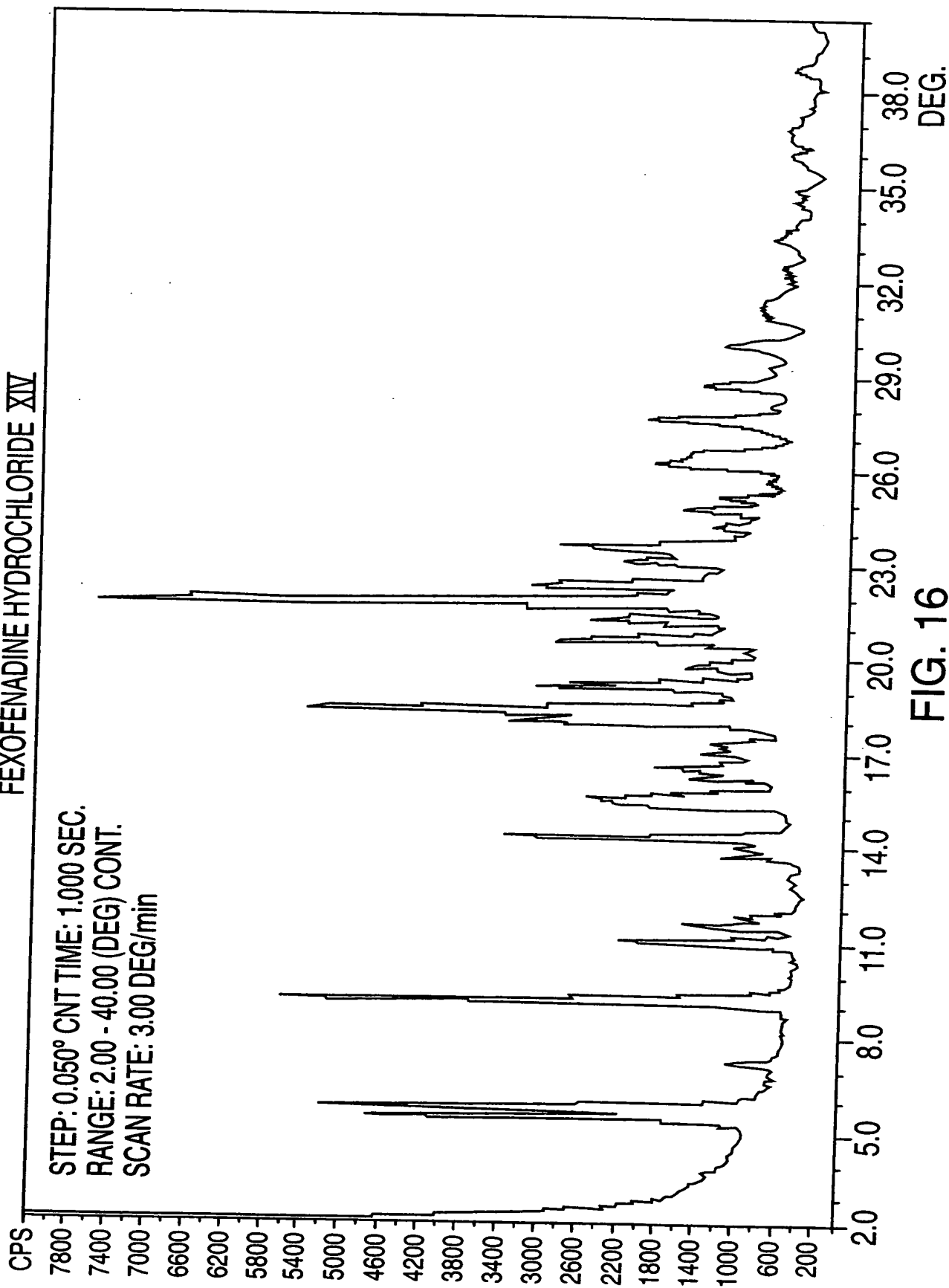


FIG. 15

FEXOFENADINE HYDROCHLORIDE XIV



FEXOFENADINE HYDROCHLORIDE XIV

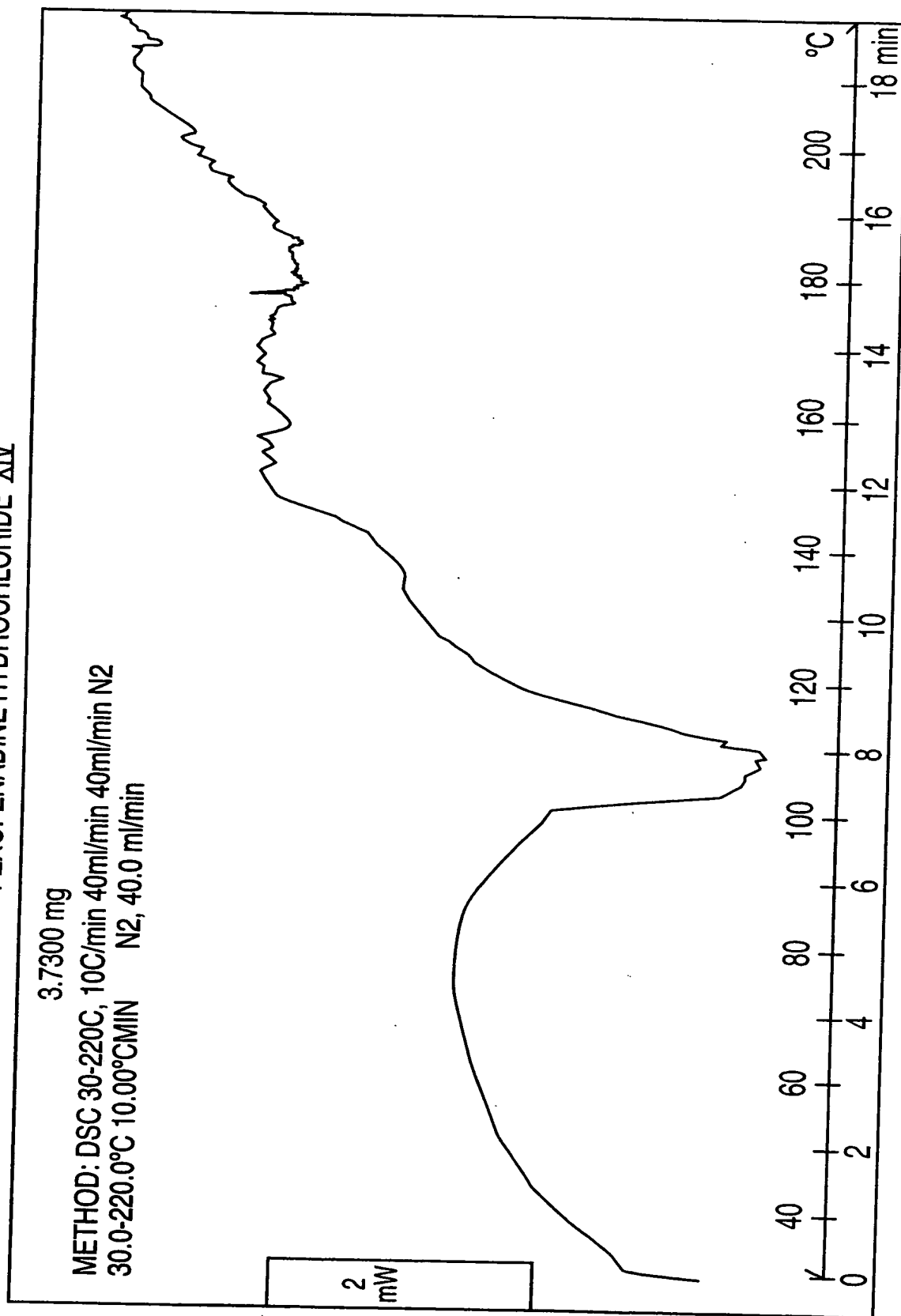


FIG. 17

FEXOFENADINE HYDROCHLORIDE XV

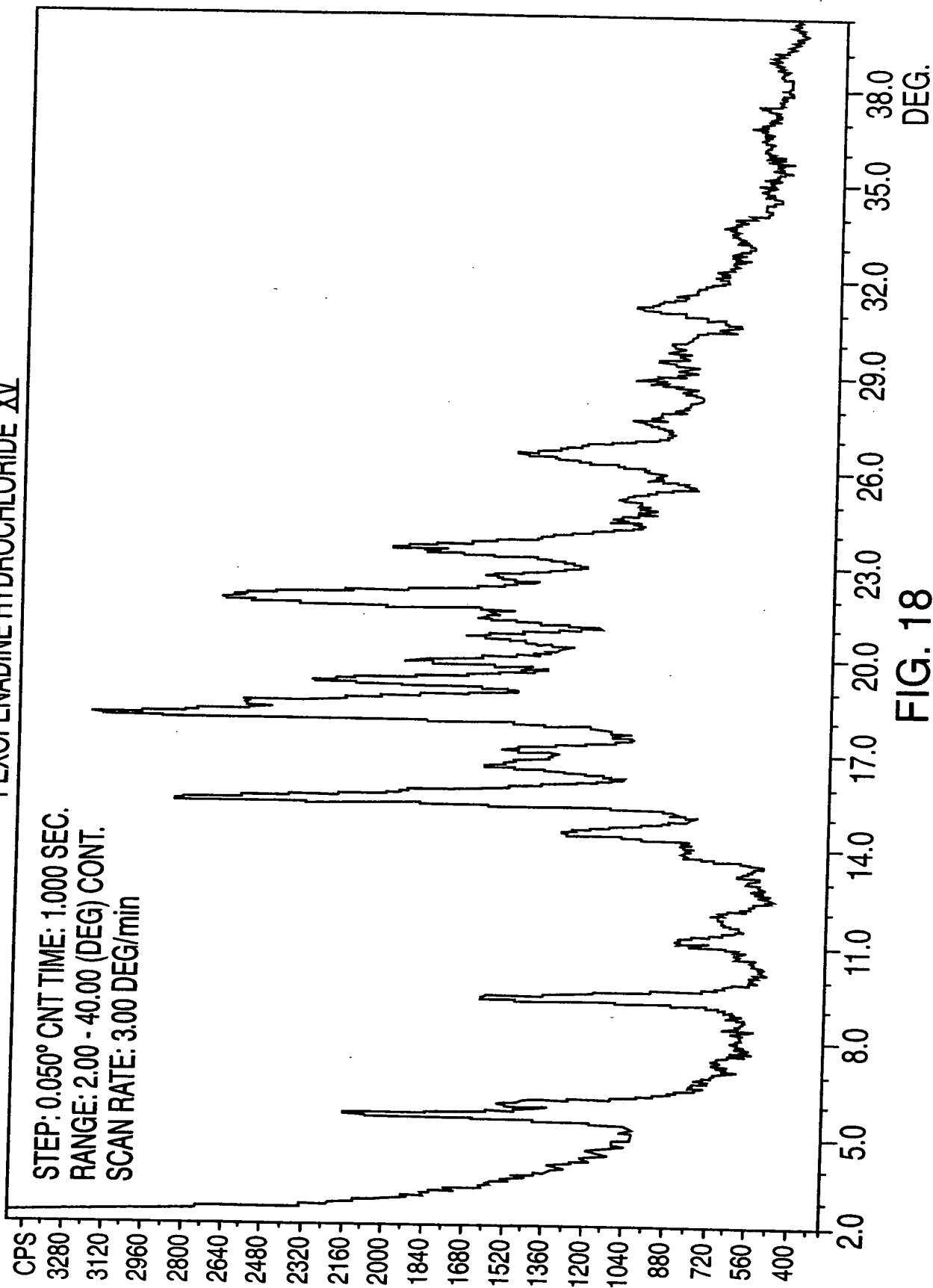


FIG. 18

FEXOFENADINE HYDROCHLORIDE XV

4.8500 mg

METHOD: DSC 30-220C, 10C/min 40ml/min 40ml/min N2

30.0-220.0°C 10.00°C/min N2, 40.0 ml/min

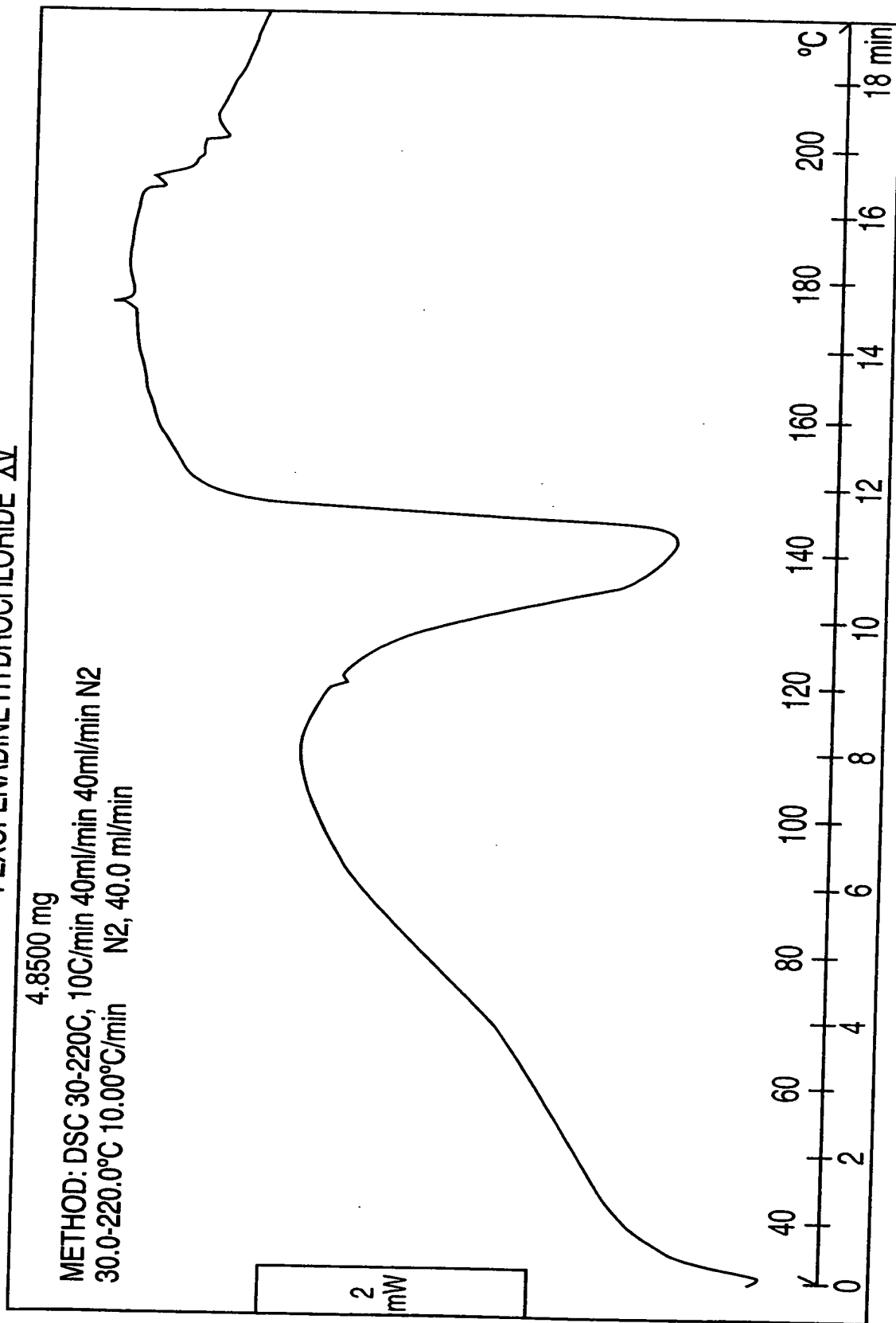


FIG. 19

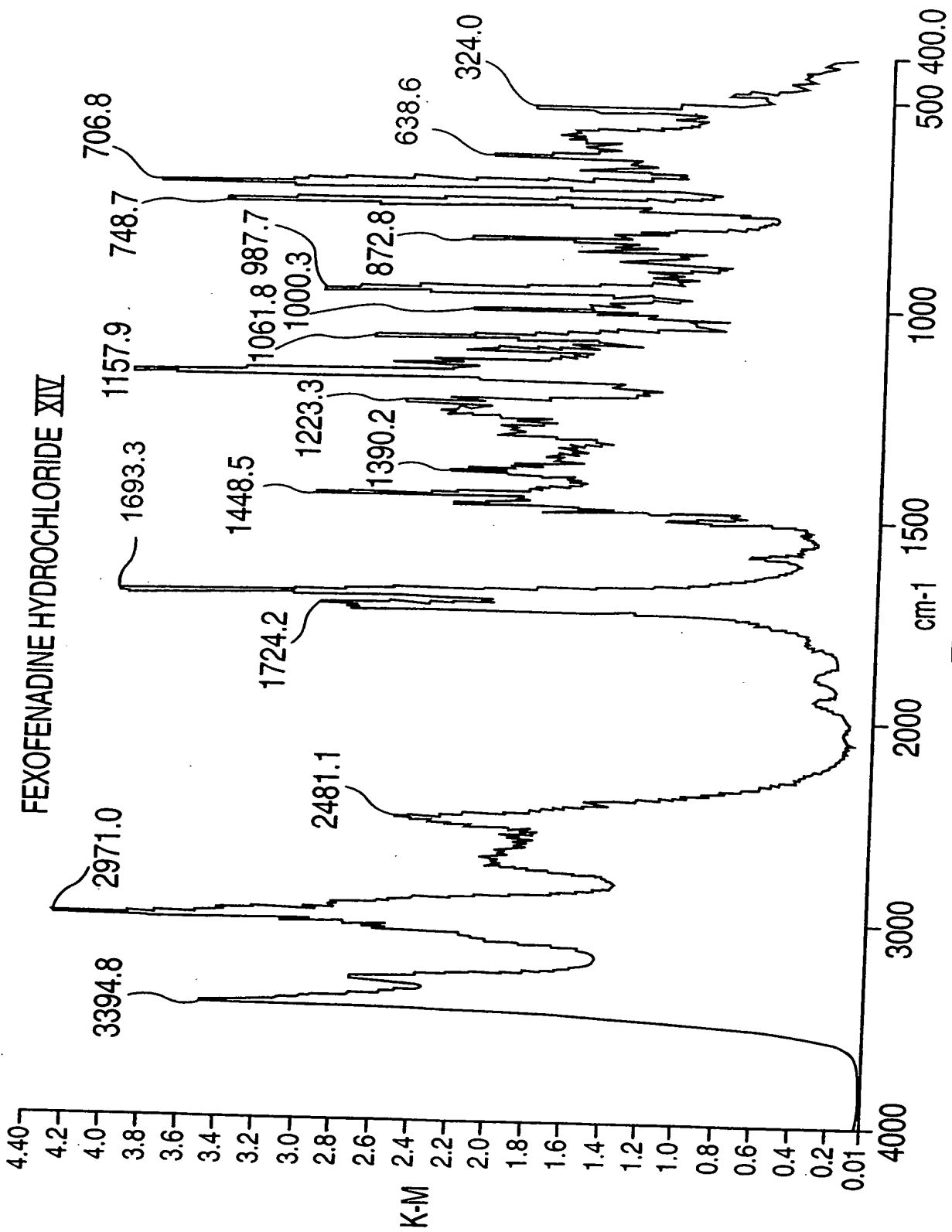


FIG 20

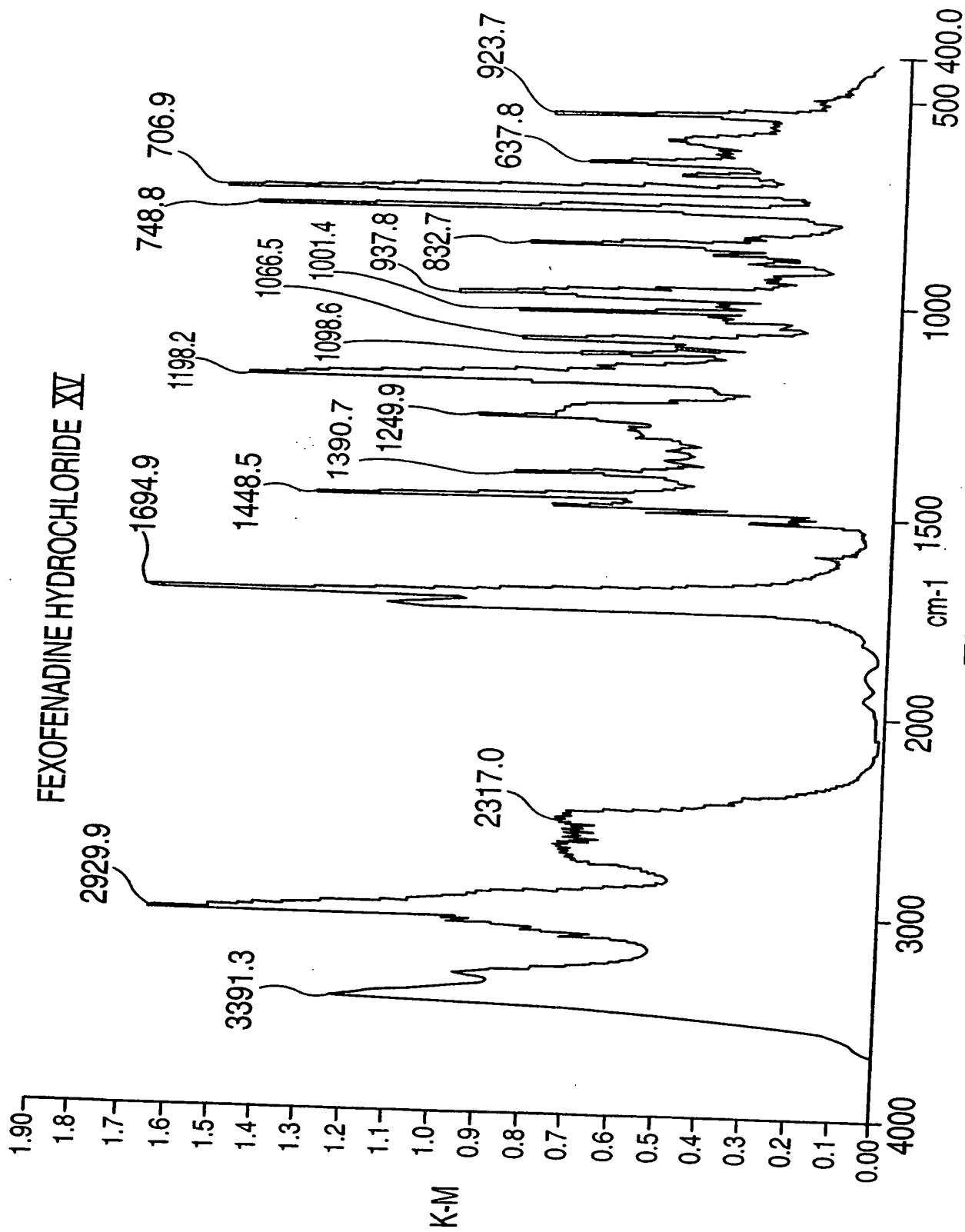


FIG. 21

AMPHORUOUS FEXOFENADINE HYDROCHLORIDE

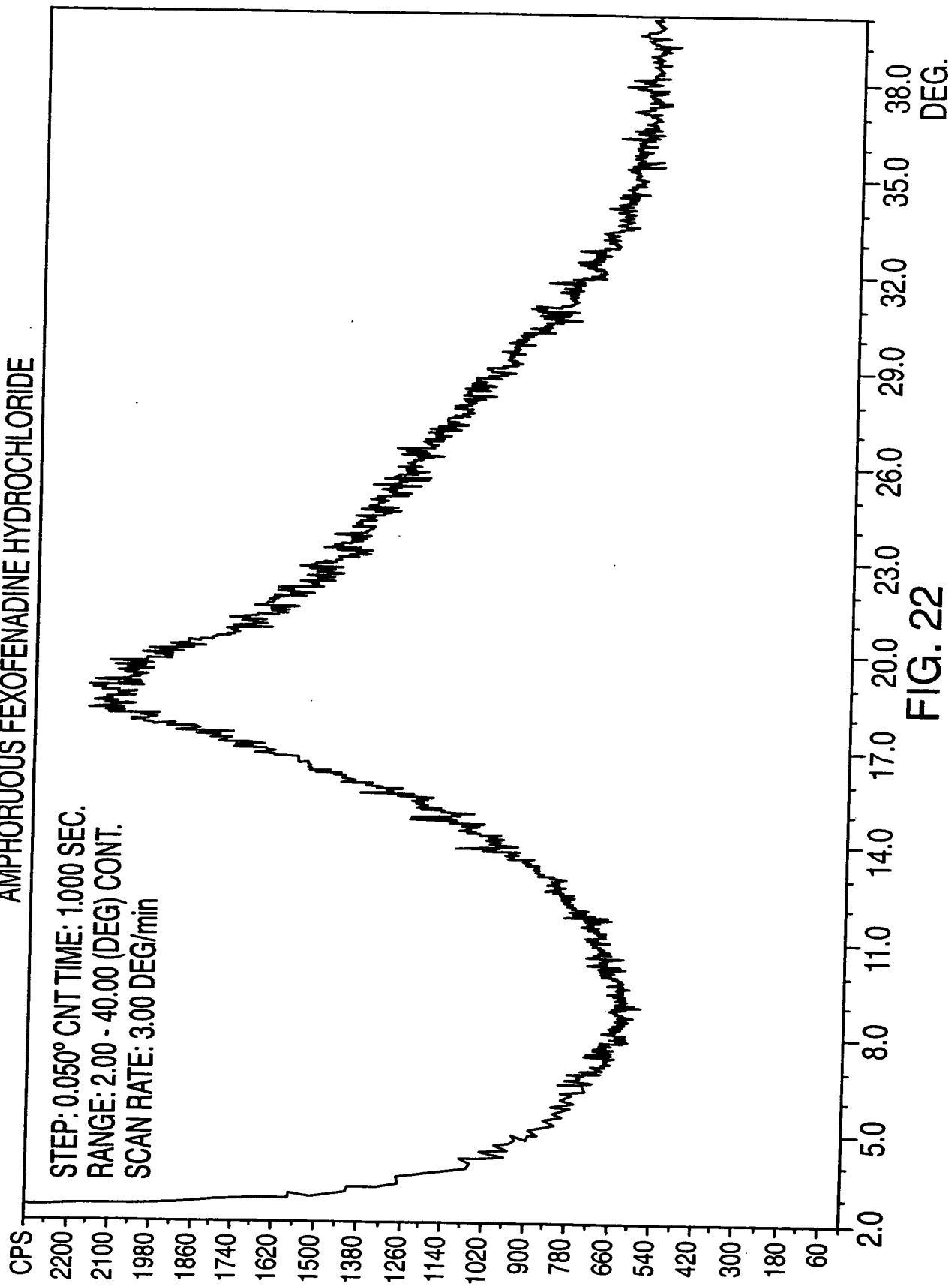


FIG. 22

Fexofenadine Hydrochloride
Form IX MTBE Solvate

TG-50 Thermal Analysis Result

Sample Weight: 11.902[mg]
Cell: Alumina
Atmosphere: Nitrogen
Flow Rate: 20[ml/min]

Temp Program
Temp Rate [C/min] 10.00
Hold Temp [C] 250.0
Hold Time [min] 0

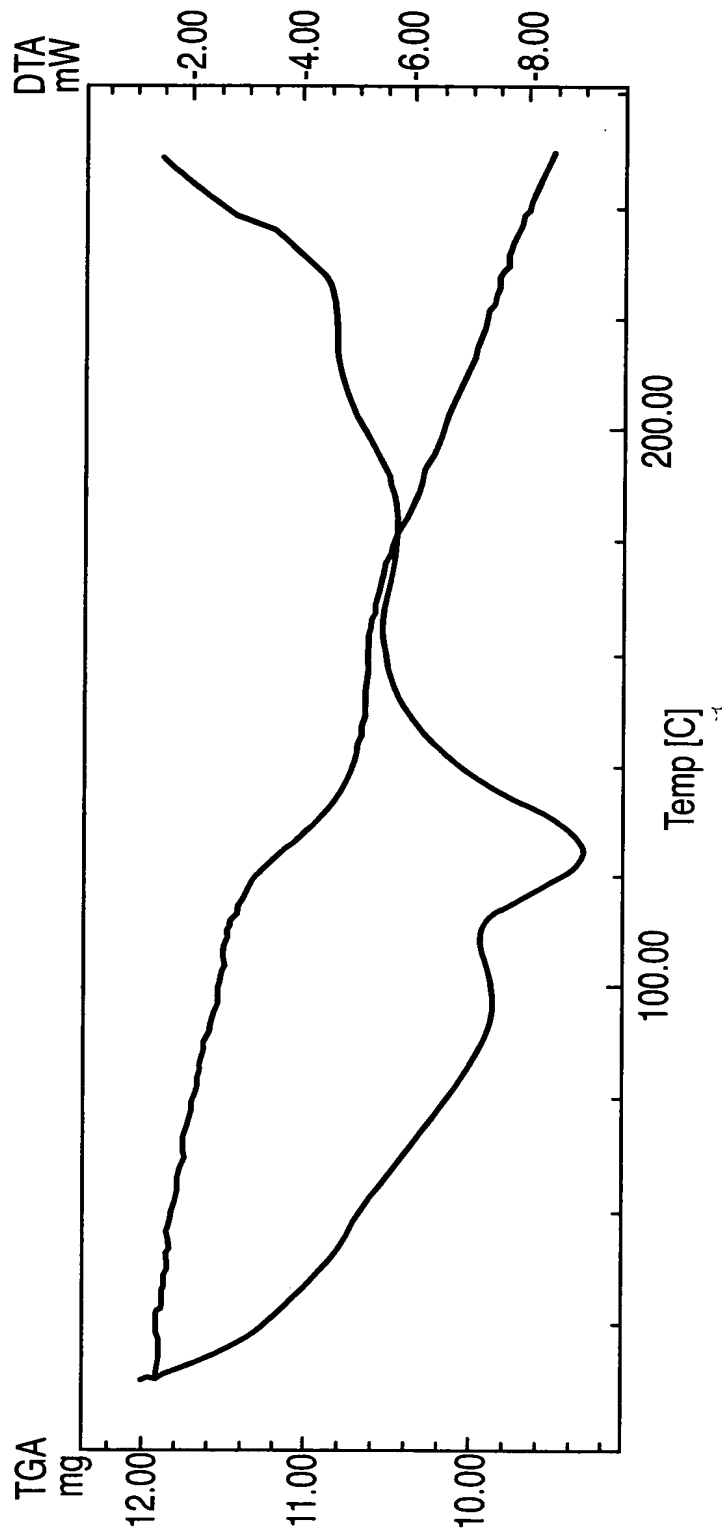


FIG. 23